

Date: Tuesday, 4/18/2006 10:07:07 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HEAD REST
 Job Number : 26692
 Estimate Number : 10423
 P.O. Number : N/A Part Number : D33033
 This Issue : 4/18/2006 S.O. No. : N/A Drawing Number : D3303 REV. AB
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : AB
 Previous Run : N/A Material : N/A
 Written By : Due Date : 5/20/2006 Qty: 8 Um: Each
 Checked & Approved By : 0604.18
 Comment : Est:A 04.09.07 New issue: KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.3135 sf(s)/Unit Total: 2.5082 sf(s) M102448
 Material: 2024-T3 (QQ-A-250/4) 0.040" thick
 (M2024T3S.040) Batch: M19295

2.0 SHEAR SHEAR



Comment: SHEAR
 Cut blank: 8.200" x 4.800" Grain along 4.800"

3.0 HAAS1 water jet HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA459 and Dwg D3303
 Stack of 8
 Identify as D3303-3

Dwg Rev AB
 Prog Rev AB

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 SECOND CHECK


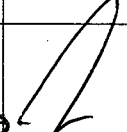
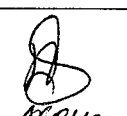


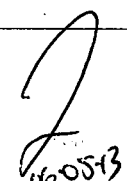
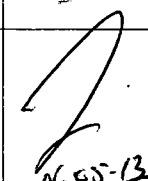
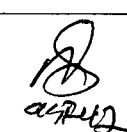
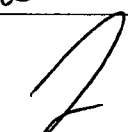
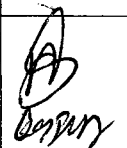
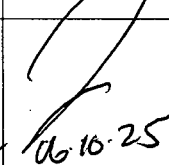
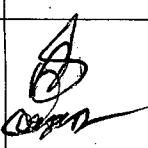
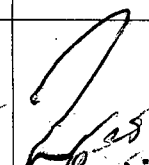


Comment: SECOND CHECK

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/10/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-10	3	Scrap two pieces. Tip hit Mat'l under the cutter, putting 2 parts crooked.		Scrap and destroy replace.	SAD 06-05-10	 06-05-13		 06-05-13
06-05-13	3	1 part cut crooked. holes to close to the edge.		Scrap & destroy. No replace.	 06-05-13	 06-05-13		 06-05-13
06/10/25	3	Scrap - DXF changed per ECN		Destroy & replace.	MM 06/10/25	 06-10-25		 06-10-25

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:07:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HEAD REST

Job Number: 26692

Part Number: D33033

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Deburr ~~SAB 06-05-16~~
- 2- C'sink nut plate holes as per Dwg D3303

SAB 06/10/26 (8)

~~SB 06-06-26~~

SAB 06/10/26 8

7.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3303

SAB 06/10/26 (8)

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAB 06-10-26 (8)

9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YH 06/10/26 X8

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SAB 06/10/26 8

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAB 06/10/26 (8)

12.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAB 06/10/26

Job Completion



U 06/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	26692
Description: Head Rest		Part Number:	D3303-3
Inspection Dwg: D3303	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.741 ✓	+/-0.010	4.747	✓			
4.221 ✓	+/-0.005	4.225	✓			
0.550	+/-0.010	0.555	✓			
0.260	+/-0.010	0.262	✓			
3.300	+/-0.010	3.297	✓			
1.500	+/-0.005	1.501	✓			
0.250	+/-0.005	0.253	✓			
Ø0.219 /	+0.005/-0.000	Ø.218	✓			
Ø0.098 /	+0.005/-0.000	Ø.101	✓			
Ø0.128 /	+0.005/-0.000	Ø.129	✓			
R0.12	+/-0.030	R.125	✓			
2.000 ✓	+/-0.005	2.002	✓			
1.371	+/-0.010	1.374	✓			
0.44 x 45°	+/-0.030					
8.100	+/-0.010	8.107	✓			
7.000	+/-0.005					
1.000	+/-0.005	1.001	✓			
0.040	+/-0.010	0.040	✓			

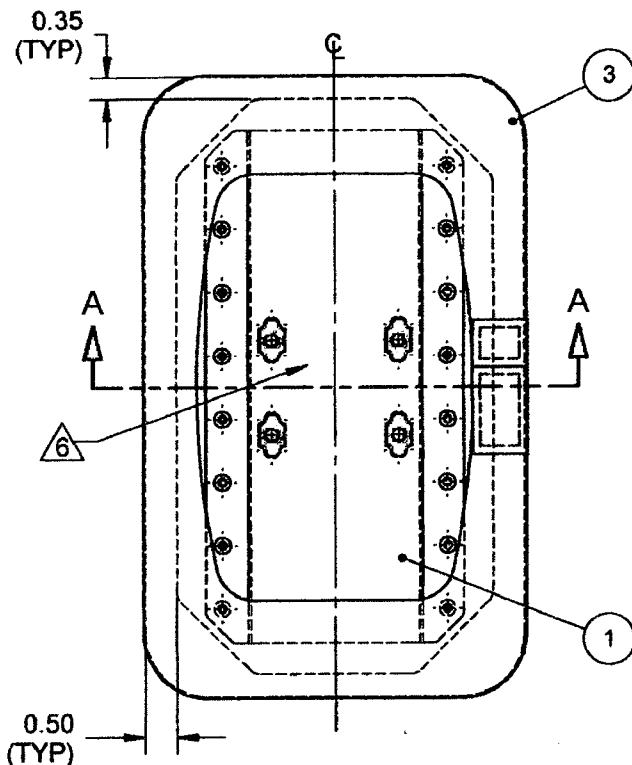
Q
N/A
Q
N/A

Measured by: <i>RE</i>	Audited by: <i>J</i>	Prototype Approval:	N/A
Date: 06.05.10	Date: 06.05.13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue	KJ/JLM	<i>[Signature]</i>

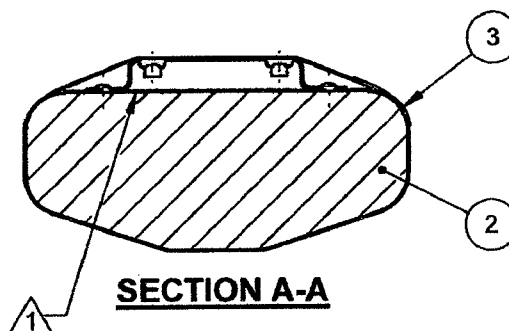


DESIGN <i>PH</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3303	REV. B SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:3
REV	DATE	DESCRIPTION	
A	04.08.18	NEW ISSUE	
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE	



RELEASED

06-09-19 *PH*



D3303-041 HEAD REST

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

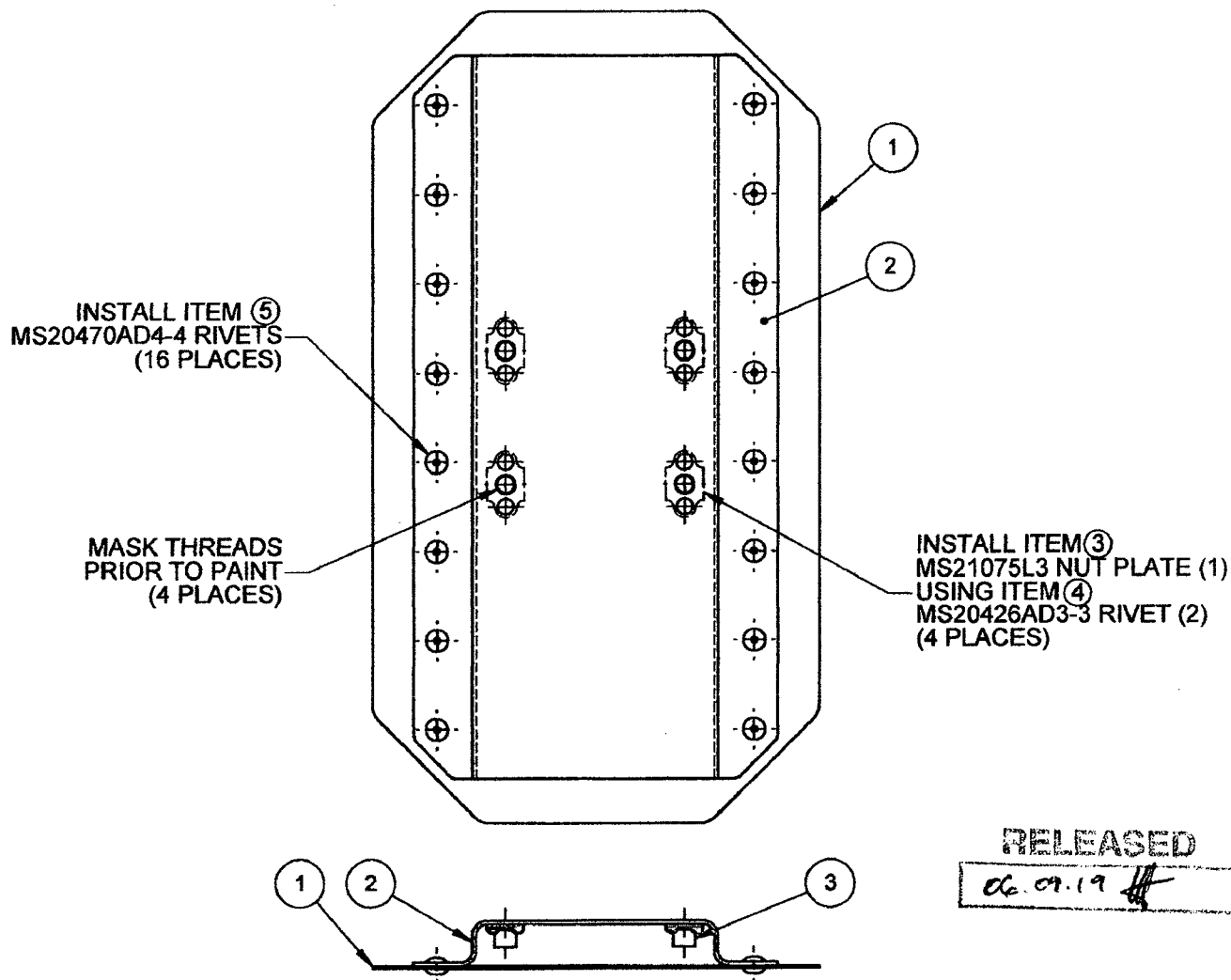
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACORDDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3303	REV. B SHEET 2 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D3303-043 BRACKET ASSEMBLY

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

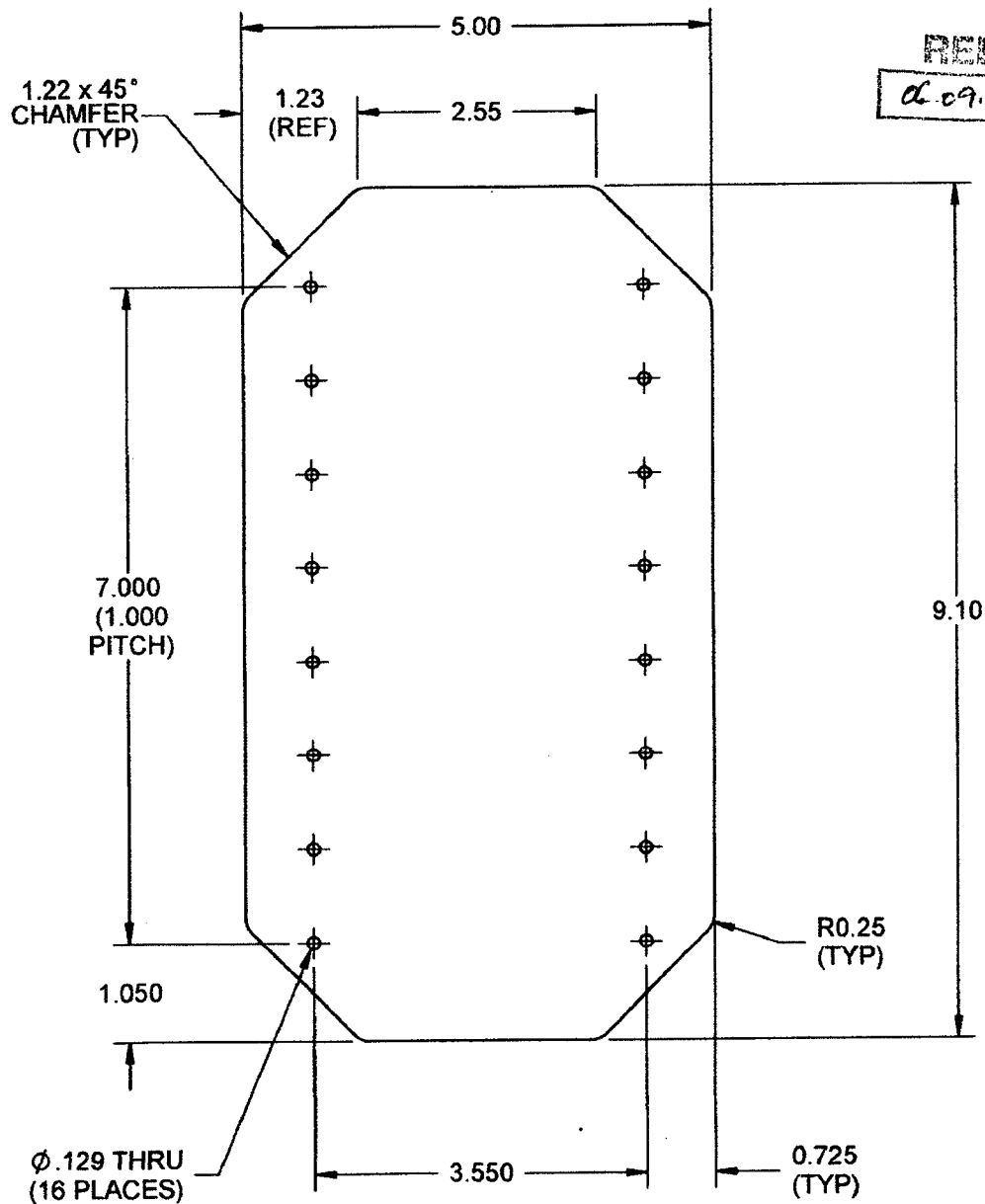
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



D3303-1 PLATE

NOTES:

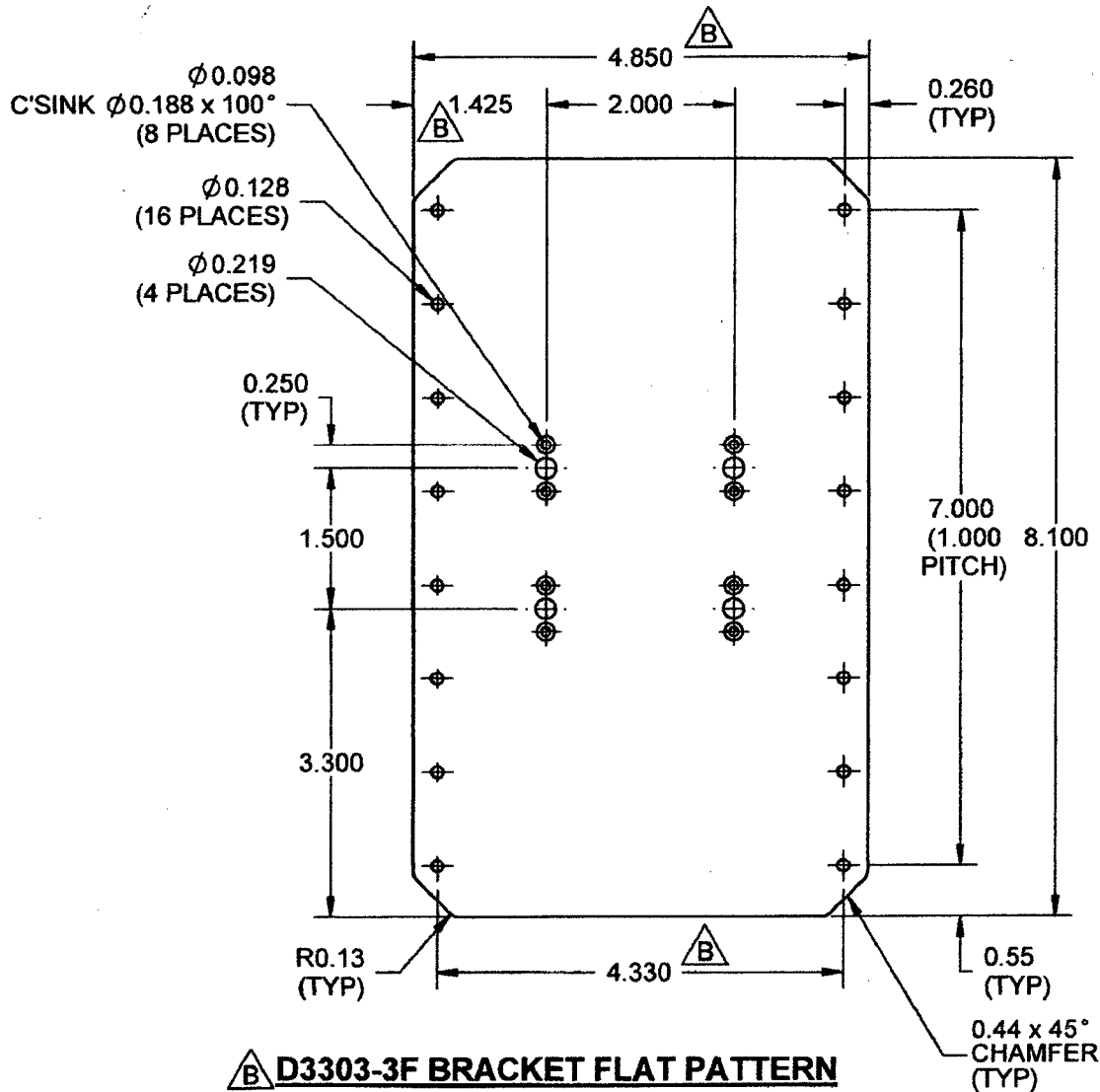
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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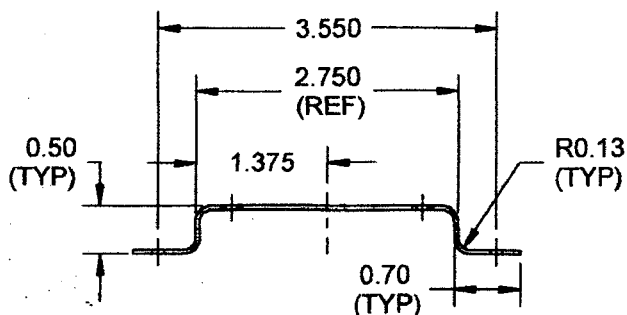
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. B SHEET 4 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE 1:2



RELEASED
06-09-19



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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